

Date: Wednesday, 6/7/2006 12:00:52 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARING ASSEMBLY
Job Number : 27433	
Estimate Number : 10716	
P.O. Number : NIA	Part Number : D3121241
This Issue : 6/7/2006 S.O. No. : NIA	Drawing Number : D3121 REV C2
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : MACHINED PARTS	Drawing Revision : C2
Previous Run : 27413	Material : NIA
Written By : <u>See Comment Below</u>	Due Date : 6/14/2006 Qty: 20 Um: Each
Checked & Approved By : <u>06-06-07</u>	
Comment : Est Rev: A 04.02.18 New issue KJ/DS	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MDELINR12500	DELIN ROUND BAR 1.25"
Comment: Qty.: 0.0546 f(s)/Unit Total : 1.0920 f(s) Material: Ø1.25 Delrin Rod (M-DELIN-R1.2500) Identify as D3121-25 Batch: M10010 M101018 MS 06106115 20		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL 1-Turn D3121-25 Cap as per Folio FA387 2-Deburr MS 06106115 20		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE MS 06106115 20		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK MS 06106116 20		
5.0	D312123	Bearing
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3121-23 Bearing B26936 SAD 06106119 20		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Data: Wednesday, 6/7/2006 12:00:53 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 27433

Part Number: D3121241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

SAD 06/06/19 20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

574.9

26/6/27 (19)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

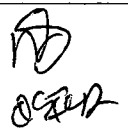
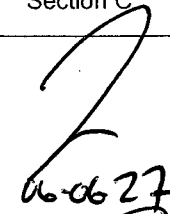

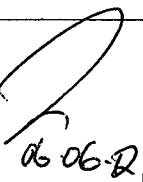
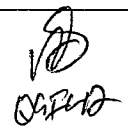

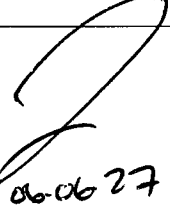
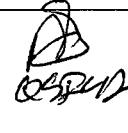

26/06/28


Job Completion




W 26/06/27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR: 27433		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-06-21	6-D	5x D3121-25 CAPS damaged when bearing was inserted!		Scrap: destroy & replace - 25 CAPS. ensure good fit, & no CAP damage.	SAD 06/06/27	 06-06-27		 06-06-21
06-06-27	6-D	1x D3121-25 CAPS. Bearing damaged when CAP changed.		destroy bearing.	 06/06/27	 06-06-27		 06-06-27

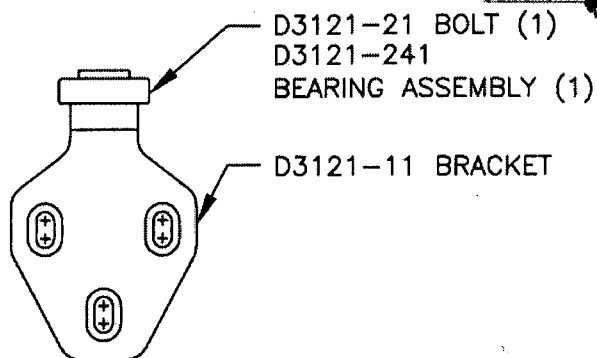
Part No: D3121-25 PAR #: N/A Fault Category: 201/600 ASS" red & SNAT1 NCR: Yes No DQA:  Date: 06/06/28

NOTE: Date & initial all entries QA: N/C Closed:  Date: 06.06.28

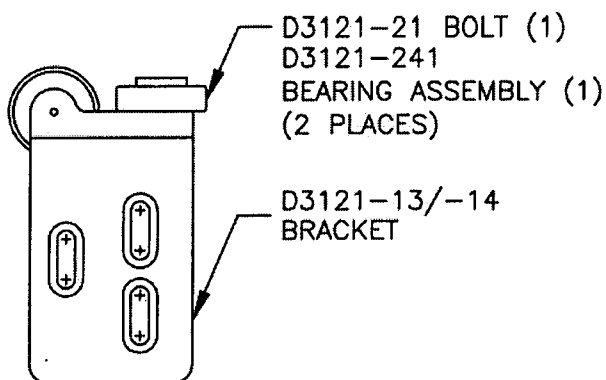


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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 1 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
C1	04.03.26	3.97 WAS 4.00; 6.11 WAS 6.14	
C2	04.04.26	0.230 WAS 0.238	

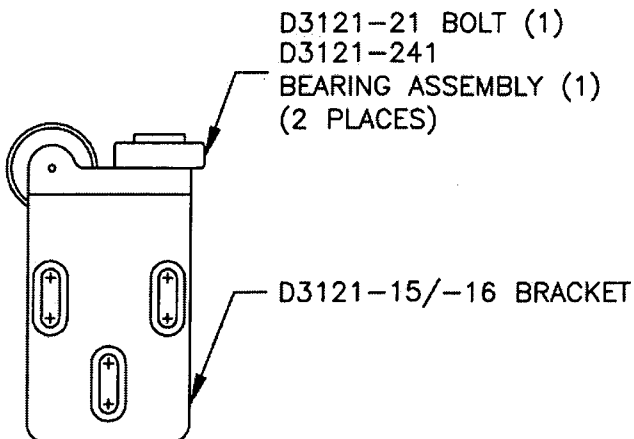
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D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

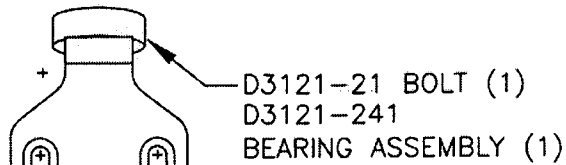
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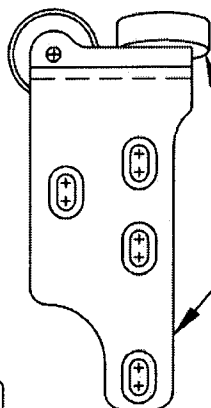
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-111 BRACKET

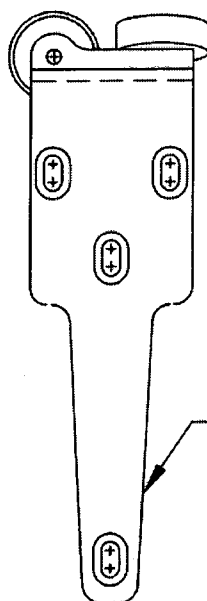
D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/06)

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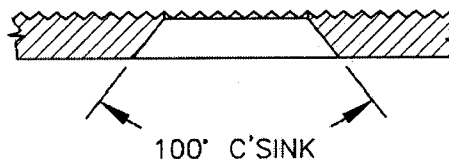
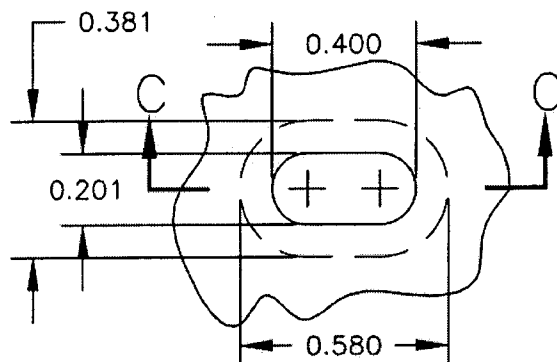
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

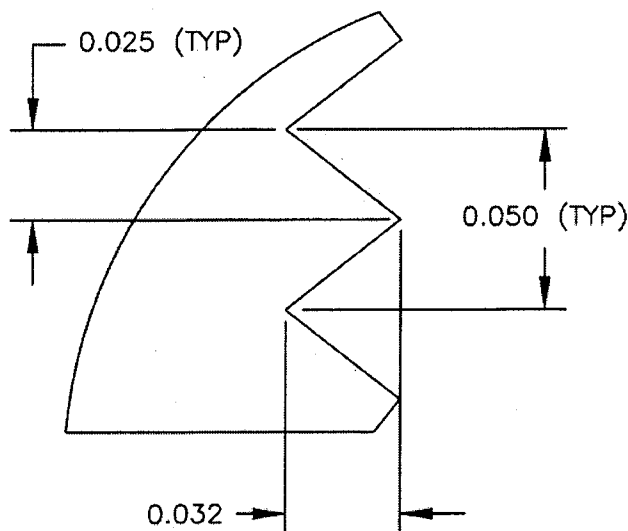
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DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20







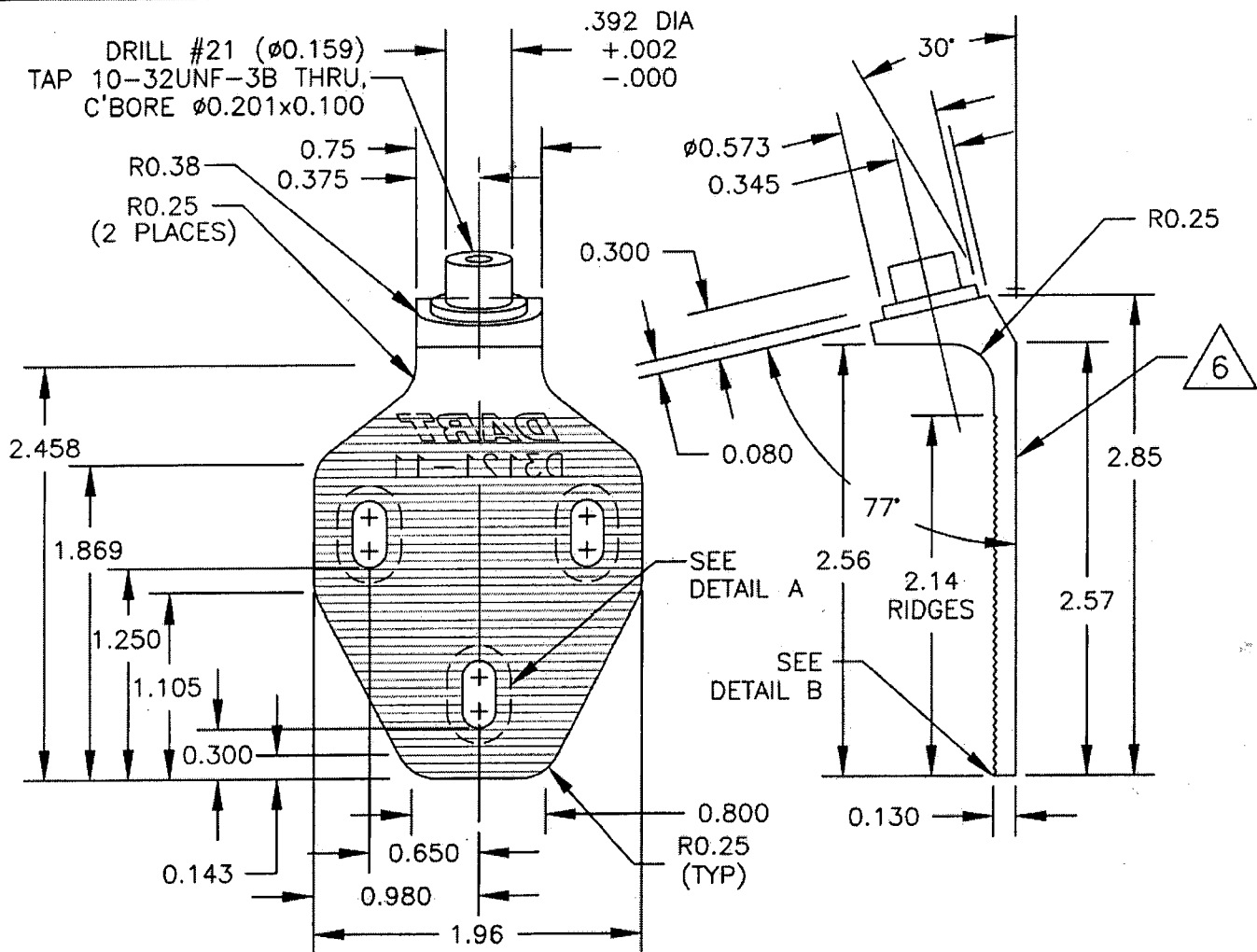
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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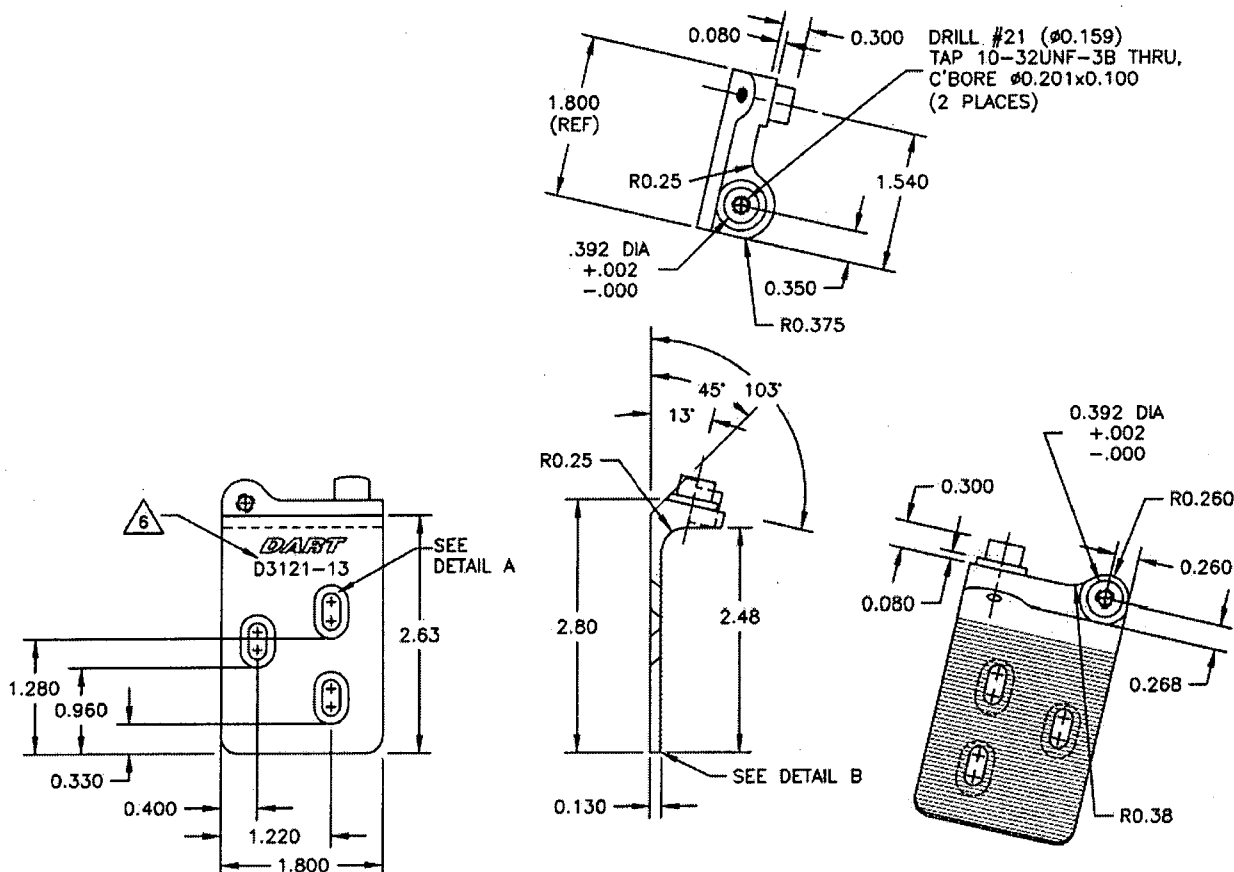
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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005.

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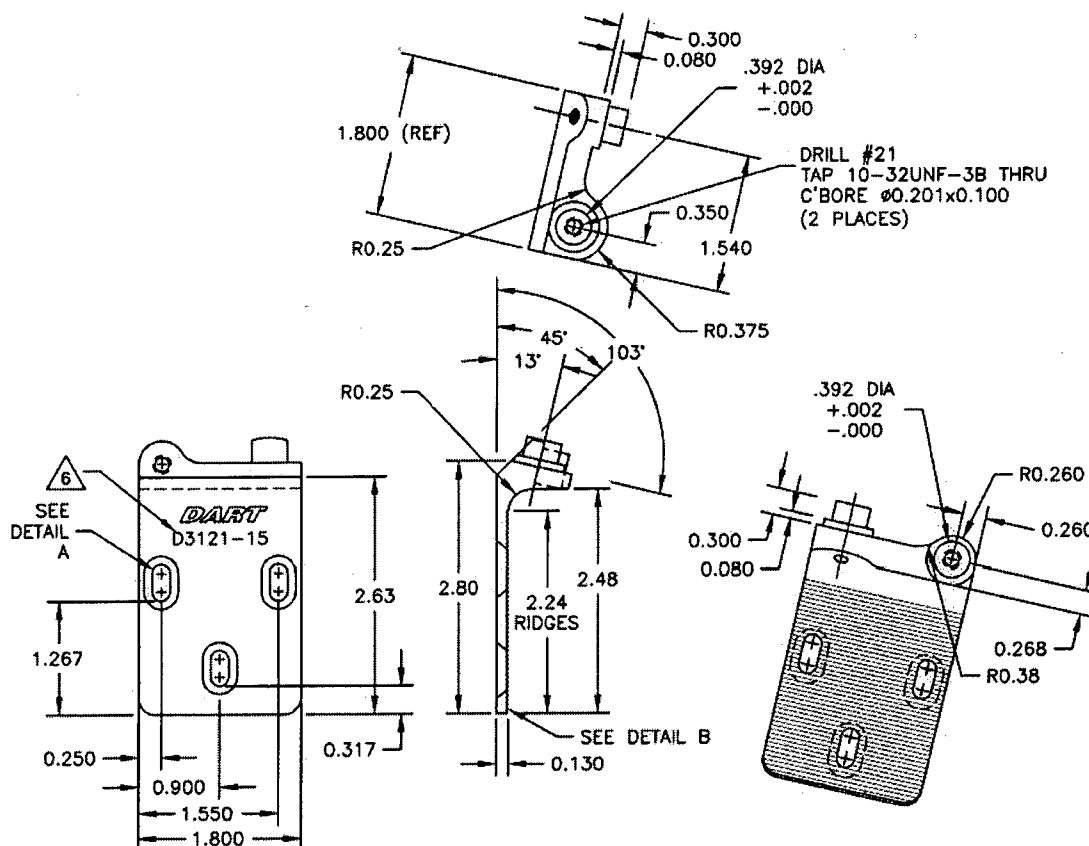
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3121	REV. C SHEET 6 OF 10
DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-15 BRACKET (SHOWN)
D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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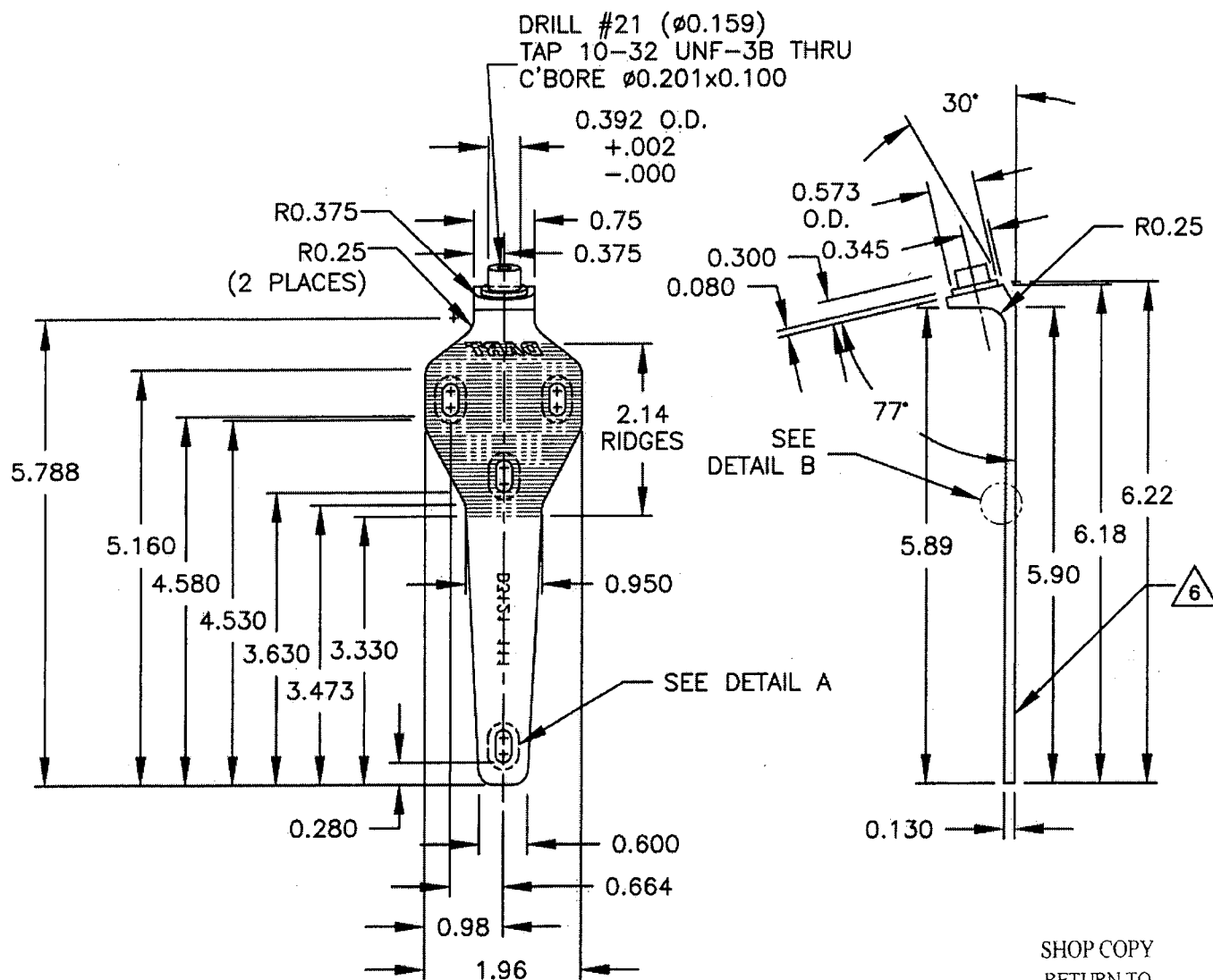
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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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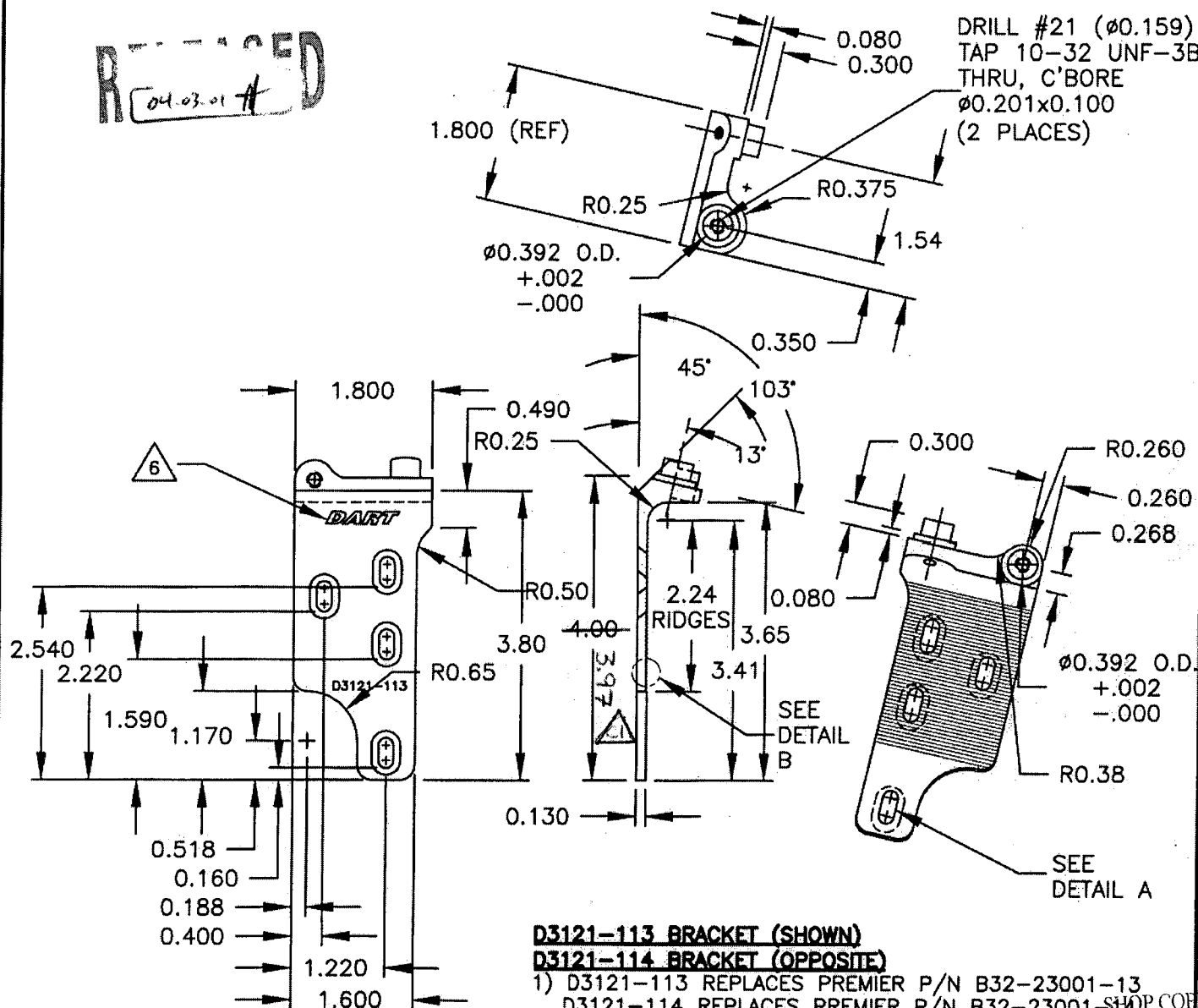
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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-113 BRACKET (SHOWN)

D3121-114 BRACKET (OPPOSITE)

1) D3121-113 REPLACES PREMIER P/N B32-23001-13

D3121-114 REPLACES PREMIER P/N B32-23001-14

2) MATERIAL: 17-4 SS PER AMS 5604/5643

(REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE STRENGTH = 150 ksi

MIN YIELD TENSILE STRENGTH = 100 ksi

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

5) BREAK ALL SHARP EDGES 0.005 TO 0.015

6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN

7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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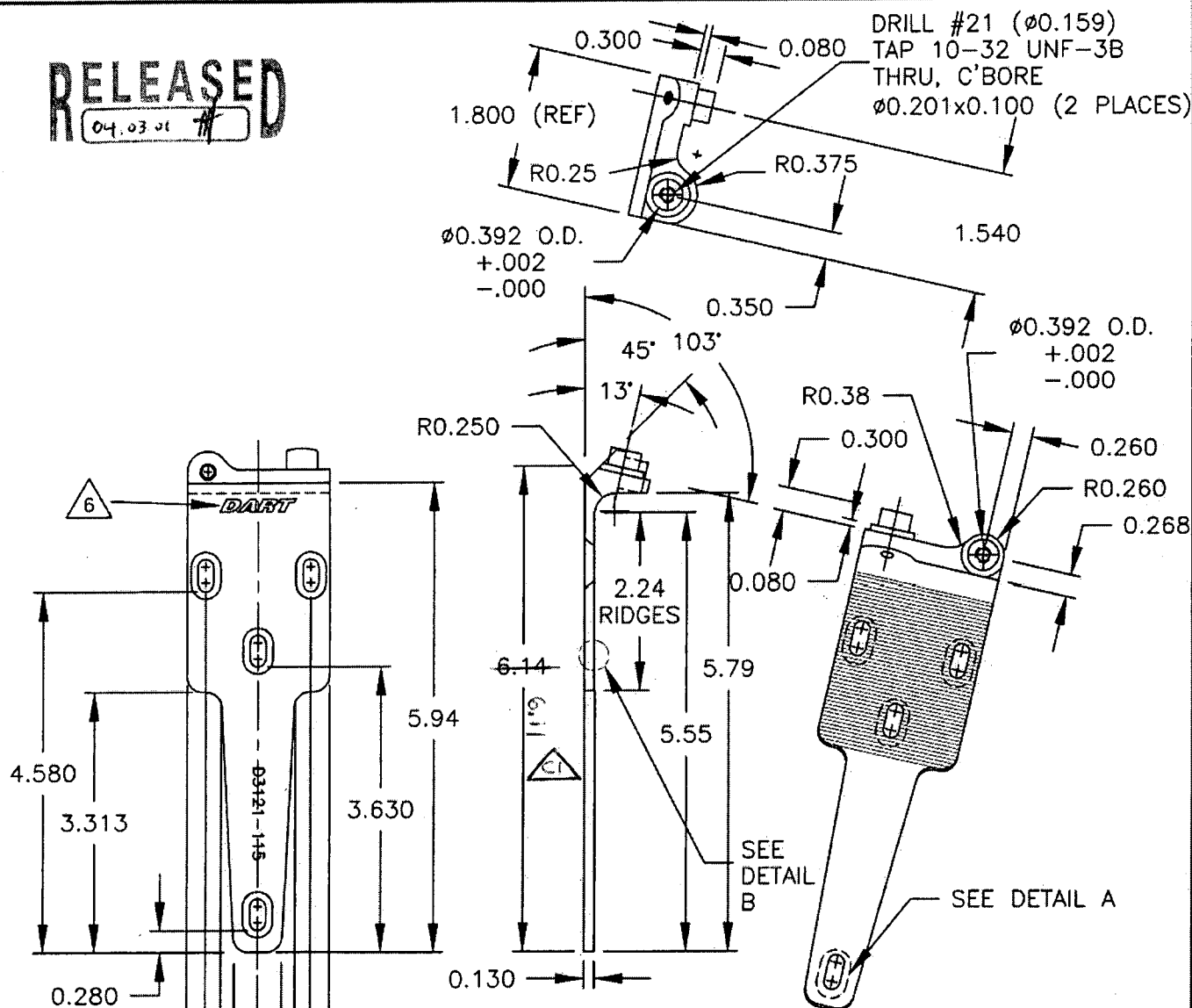
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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2

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D3121-115 BRACKET (SHOWN)

D3121-116 BRACKET (OPPOSITE)

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

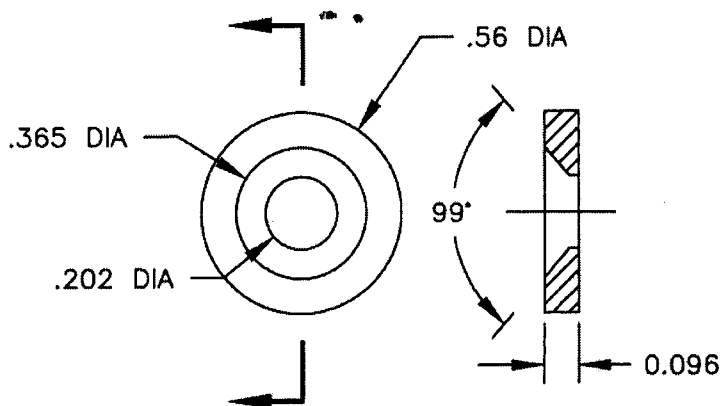
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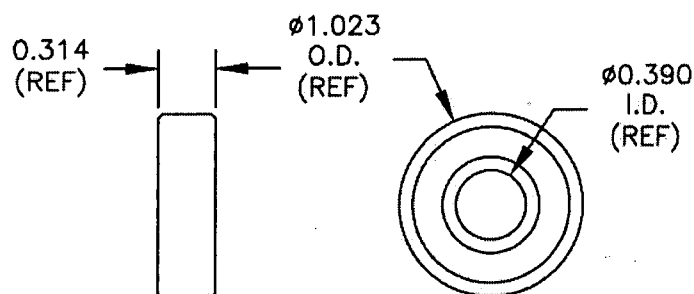
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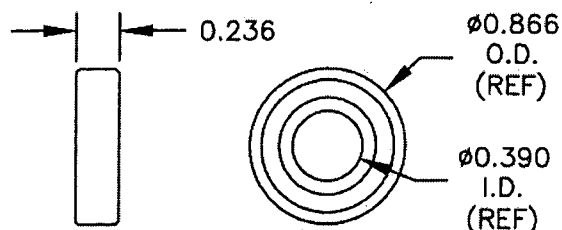
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

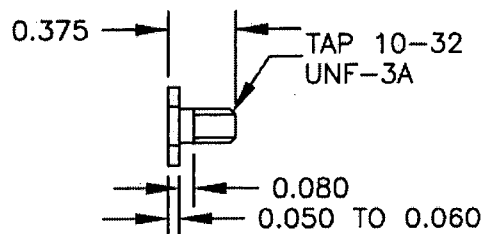
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

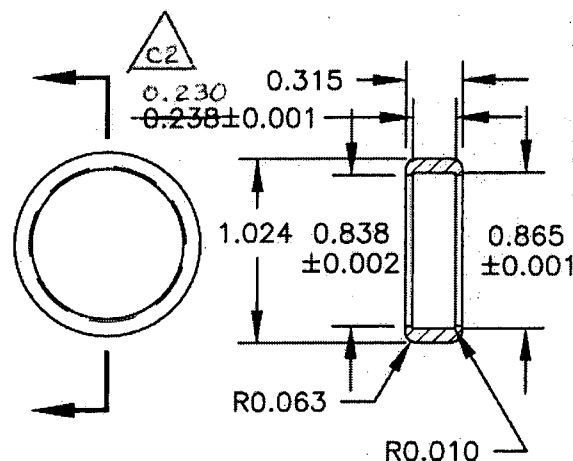
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

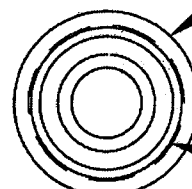
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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04.03.01

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